

CLAIM AMENDMENTS

Claim 1. (previously presented) Method to process monitor and control a machine for continuous bending of long products (11) to a predetermined radius, characterized in that three parallel contact-free distance meters (20 - 22) are used and the distances are measured to the bent surface on the product (11), the actual bending radius is calculated based on the fixed distances between the meters and the measured distances, and adjustment of the machine is carried out in response to the calculated actual radius in relation to the desired radius, and in that for the calculation, the bending radius between the measuring points is approximated by means of a second-degree polynomial.

Claim 2. (original) Method according to claim 1, characterized in that laser transmitters (20 - 22) are used.

Claim 3. (cancelled)

Claim 4. (cancelled)

Claim 5. (previously presented) Machine for continuous bending of long products to a predetermined radius, comprising a bending device and a feeding device for feeding the long product

through the bending device, characterized by three parallel contact-free distance meters for measurement of the distances to the bent surface of the long product, a processor coupled to the distance meters for calculation of the actual bending radius and coupled to control the adjustment of the machine in response to the relation between the calculated actual bending radius and the desired radius, wherein, for the calculation, the bending radius between the measuring points is approximated by means of a second-degree polynomial.

Claim 6. (cancelled)

Claim 7. (cancelled)

Claim 8. (cancelled)

Claim 9. (cancelled)